

Date: Monday, 22/12/2008 3:05:06 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 44232	
Estimate Number : 10711	
P.O. Number :	Part Number : D32131
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3213
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 43553	Material :
Written By :	Due Date : 12/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 08.10.23</u>	
Comment : Est Rev:A 05-11-17 New Issue JLM Est Rev:B 07-02-13 Now on Waterjet JLM Est Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4950 sf(s)/Unit Total : 2.9698 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063)Identify as D3213-1
Batch: 110337 IB 9-1-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3213
Dwg Rev: A
Prog Rev: A

IB 9-1-9

(10)

2-Deburr if necessary

IB 9-1-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-1-9

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/06/09 (410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 44232

Part Number: D32131

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Handwritten: n145

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 98 09-01-20 (x10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 98 09/01/20 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 180

Handwritten: 98 09/01/21 (x10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/01/26

Job Completion

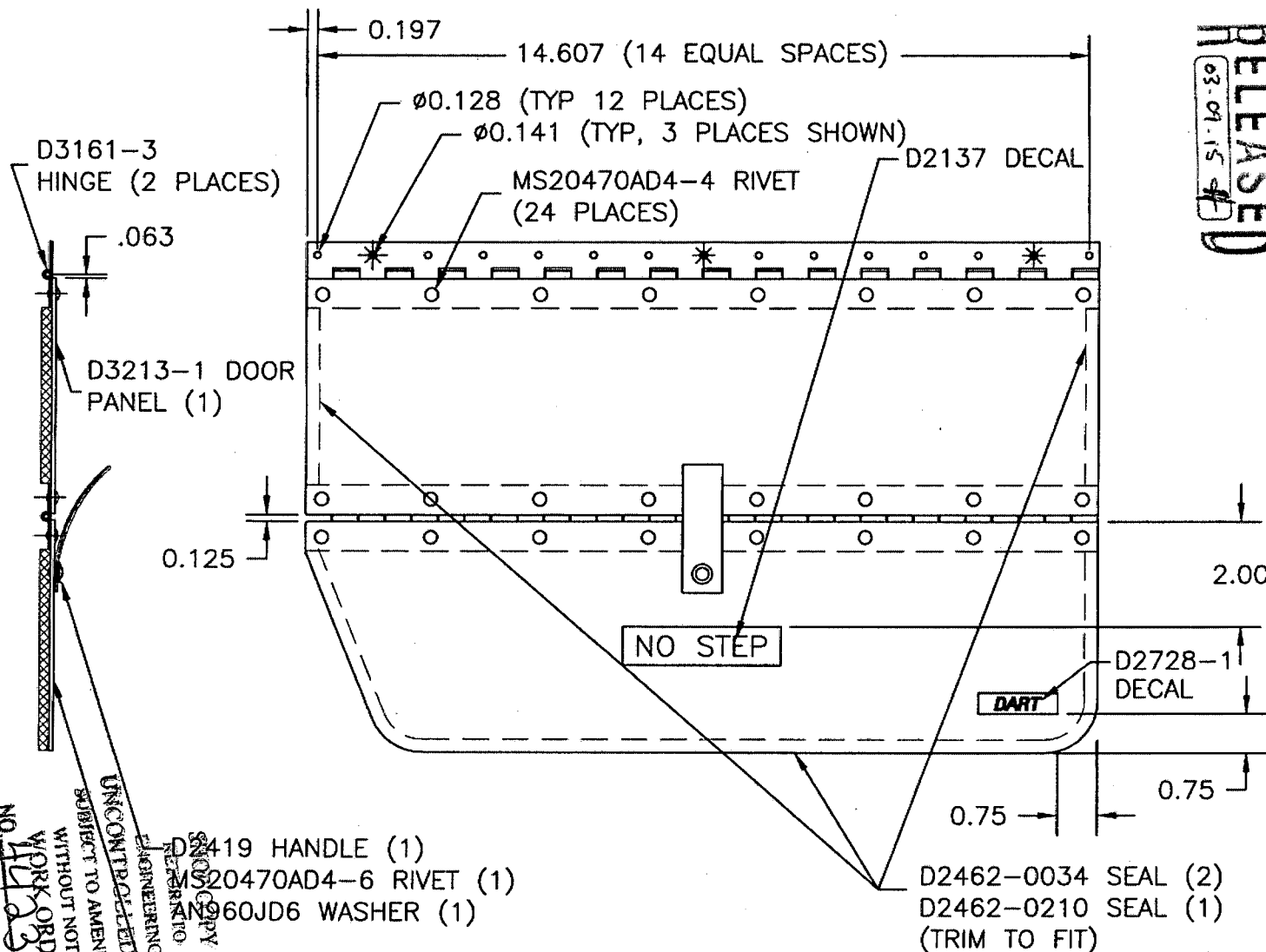


Handwritten: MF 09-01-22



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP	DRAWING NO.	REV. A
CHECKED	APPROVED	D3213	1 OF 2
DATE	TITLE	DOOR ASSEMBLY	SCALE
03.09.03	NEW ISSUE		1:3

RELEASED
83-01-15-40



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WITHOUT NOTICE
WORK ORDER
NO. 44032

D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

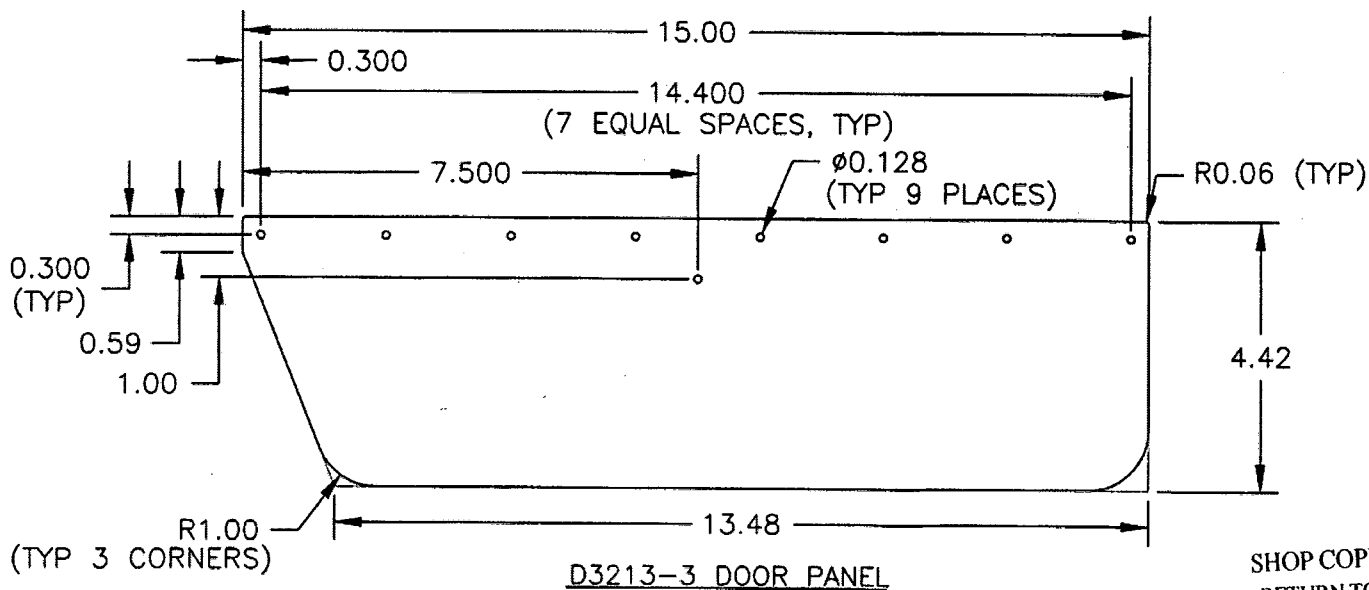
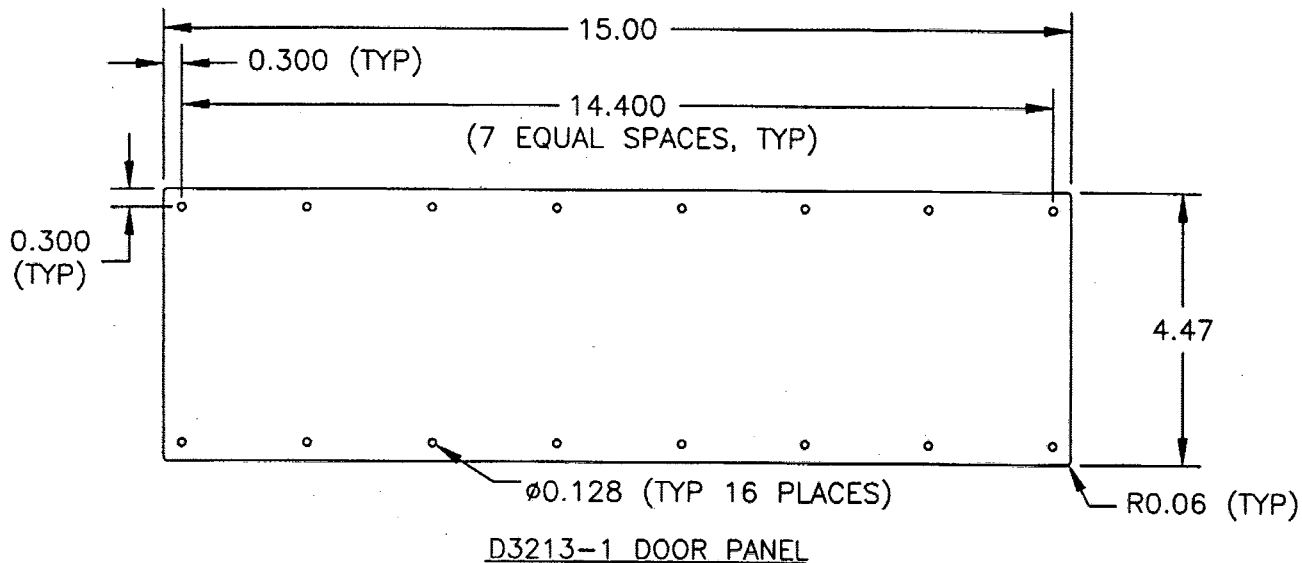
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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03.09.15
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WORK ORDER
NO. 44232

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